

Date: Monday, 6/5/2006 7:46:59 AM
 User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|--|----------|----------------|------------------------------|------------------|-----|
| Customer | CU-DAR001 Dart Helicopters Services | | Drawing Name | : SPACER | | |
| Job Number | : 27361 | | Part Number | : D2346 | | |
| Estimate Number | : 11845 | | Drawing Number | : D2346 REV B | | |
| P.O. Number | : N/A | | Project Number | : N/A | | |
| This Issue | : 6/5/2006 | S.O. No. | : N/A | | Drawing Revision | : B |
| Prsht Rev. | : NC | | Material | : N/A | | |
| First Issue | : N/A | | Due Date | : 6/20/2006 Qty: 20 Um: Each | | |
| Previous Run | : N/A | | | | | |
| Written By | <i>[Signature]</i> COMMENT Below | | | | | |
| Checked & Approved By | <i>[Signature]</i> 06.06.05 W | | | | | |
| Comment | : Est. G 02.03.05 Re-format to machine in house NG | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | | |
|---------|-----------------------|---|--|--------------------------------|
| 1.0 | M6061T6T0375W035 | 6061-T6 Tube .375 x.035W | | |
| | | Comment: Qty.: 0.1094 f(s)/Unit Total : 2.1882 f(s) 6061-T6 Tube .375 x.035W Material: 6061-T6 (WW-T-700/6) .375 Ø x 0.035 wall. Batch <u>M17666</u> | | <i>[Signature] 06/06/15</i> |
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 | | |
| | | Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA198 <i>N/A Machined Manually</i> Deburr | | <i>[Signature] 06/06/16 20</i> |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | <i>[Signature] 06/06/16 20</i> |
| 4.0 | QC8 | SECOND CHECK | | |
| | | Comment: SECOND CHECK | | <i>[Signature] 06/06/16 20</i> |
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 | | |
| | | Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 | | <i>[Signature] 06/06/17 20</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 06/06/02

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Monday, 6/5/2006 7:46:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 27361

Part Number: D2346

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/06/20

(20)

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST40

20/06/21

(20)

8.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/21

(20)

Job Completion



U 06.06.21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



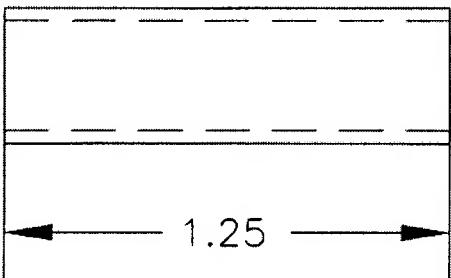
| | | |
|-------------------------------|--------------------------------|---|
| DESIGN BW | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2346 |
| DATE 99.12.15 | | TITLE SPACER |
| | | SCALE 2:1 |
| A | 95.01.05 | NEW ISSUE |
| B | 99.12.15 | ADD FINISHING |

RELEASED
99.12.21 DS

UNDER REVIEW

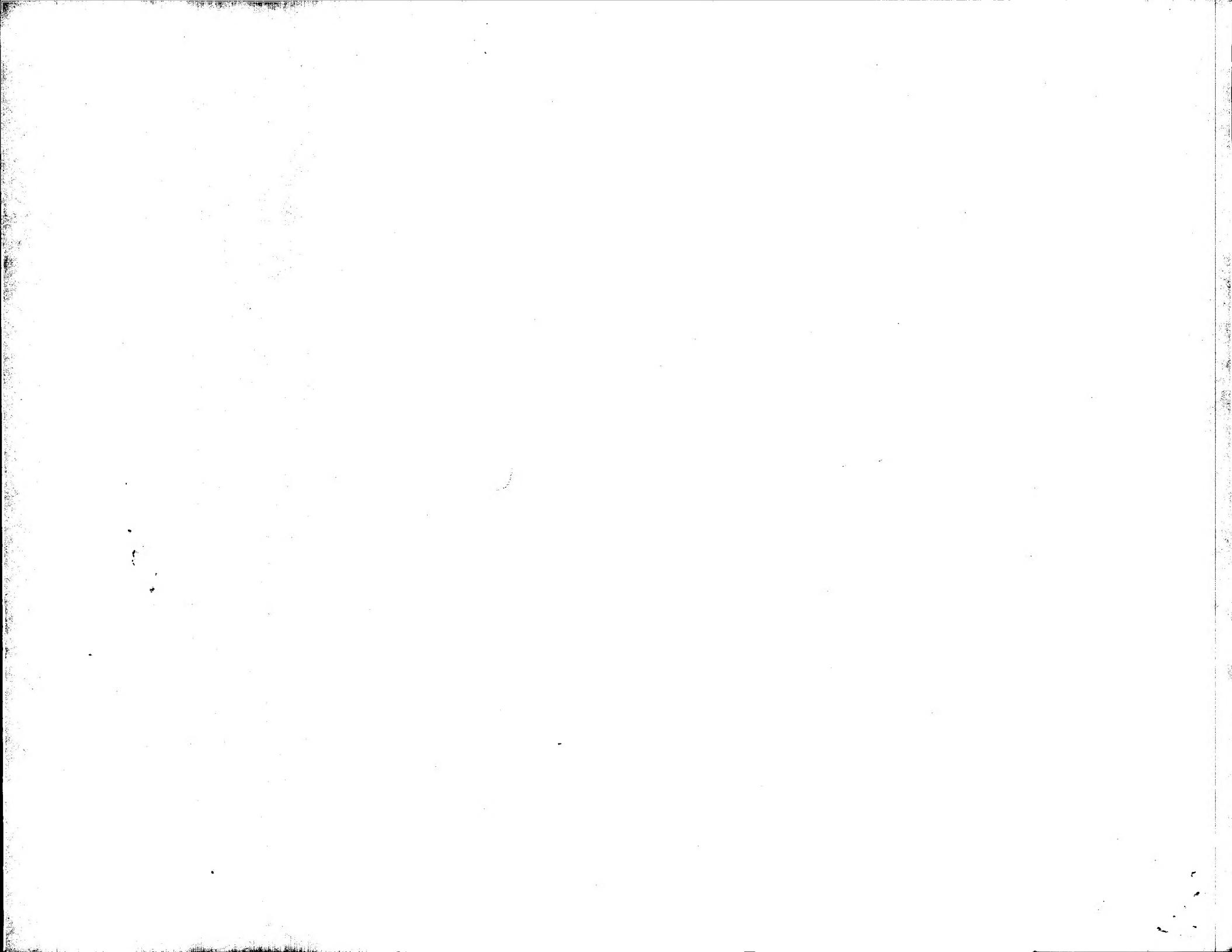
01.03.15 CP

• DESIGN OK, BUT CHECK WITH
JB BEFORE MANUFACTURE



MATERIAL: 6061-T6 (WW-T-700/6) 0.375 DIA x 0.035 WALL
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK SHARP EDGES 0.010 TO 0.020

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27361



| | | |
|-------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 27361 |
| Description: SPACER | Part Number: | D 2346 |
| Inspection Dwg: D 2346 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| | | | | | |
|--------------|---|-------------|---|---------------------|--|
| Measured by: |  | Audited by: |  | Prototype Approval: | |
| Date: | 06/06/16 | Date: | 06/06/16 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/RF | |